

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000112**Date Inspected:** 26-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1130**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, Martinez

CWI Name:	Kevin Carpenter & Bernard P. Docena			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Procedure Qualification Record		

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspectors Mr. Mark Wright and Mr. Robert Cuellar are present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/ Flour for the purpose of witnessing Procedure Qualification Record tests. The following items have been observed,

- 1)Quality Control Manager (QCM) Mr. James S. Bowers is present along with ABF representative Mr. Tommy Gibson.
- 2)The QCM provided Caltrans QA with, PQR document representing identification number ABF-PQR-002-1, Material Test Reports for one inch thick and three eighths thick ASTM A 709 Grade 50W plates, Lincoln Electric operating procedure for Innershield NR-232 electrode, American Welding Society wallet card for Certified Welding Inspector Mr. Bernard P. Docena and also Jaeger J2 eye exam for Mr. Bernard P. Docena.
- 3)There was a two hour delay from when the PQR test was scheduled to the time the flux cored arc welding root pass was applied. The QCM accepted the responsibility for this delay due to the lack of detecting that the scheduled PQR test was to be tested as an AWS D1.5 (2002) section 5.13 test rather than the original assumption of a 5.12 test. The QCM voiced that he did not detect that the flux cored arc welding consumable was not listed as a filler metal in AWS D1.5 (2002) Table 4.1 rather it is listed as a filler metal in AWS D1.5 (2002) table 4.2.
- 4)Caltrans QA observed a root and a second flux cored arc welding pass that was applied to a procedure qualification record test attempt. Both the root and the second filler pass contained visual discrepancies relative to poor weld profiles with excessive weld reinforcement and also liner voids that occur along the edges of the root pass. Mr. James Bowers directed the welder to grind the weld profile of the root pass. The second filler pass was of poor visual quality due to the weld profile.

The QCM Mr. James Bowers terminated the witnessing of this PQR test after the visual examination of the second pass of this test.

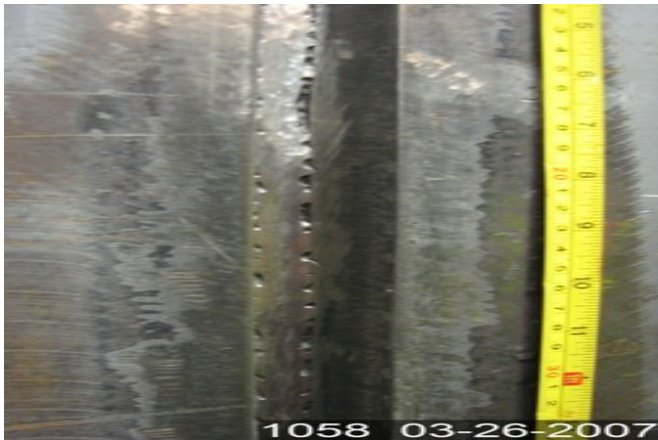
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For specific welding parameter values recorded during this procedure qualification record test see the Caltrans TL-6032 generated for this date.

Summary of Conversations:

1) Caltrans QA Inspector Mr. Mark Wright questioned Mr. Bowers as to whether or not he has provided the parties present for this PQR test with the Caltrans generated PQR welding parameter Excel spreadsheet and also the flow charts of such PQR tests. Mr. Bowers responded that he has not provided this to the Quality Control present or the Ironworkers apprenticeship. 2) Mr. Bowers voiced that American Bridge / Fluor would like to utilize the remainder of this date as practice in an effort to remedy the welding parameters and the welding profiles. Mr. Bowers added that ABF would like to reschedule procedure qualification record testing on Tuesday 03-27-2007.



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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Cuellar,Robert	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
